

Date: Tuesday, 03/10/2006 11:48:55 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : HINGE BRACKET
<b>Job Number</b> : 28822	
<b>Estimate Number</b> : 12543	
<b>P.O. Number</b> :	<b>Part Number</b> : D35381
<b>This Issue</b> : 03/10/2006 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3538 UNDER REV
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : UNDER REVIEW
<b>Previous Run</b> :	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 10/10/2006 <b>Qty:</b> 2 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	
<b>Comment</b> : Est Rev:A New Issue 06-10.03 EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6B0750X01500	6061-T6 Bar .75" X 1.5"
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**Comment:** Qty.: 0.1995 f(s)/Unit Total: 0.3990 f(s)

6061\_T6 Bar 0.750 x 1.500

Batch: M15031

*EC 06.10.03*

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** 1-Machine as per Folio FA651 and Dwg D3538

2-Deburr

*EC 06.10.03*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

*EC 06.10.03*

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

*SA 06.10.04*

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*Q.M 06-10-04*

*(2)*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET

Job Number: 28822

Part Number: D35381

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*Q M 06-10-04*

*(2)*

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*FC 06 10 04*

*(2)*

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*06-10-06*

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*u 06-10-06*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

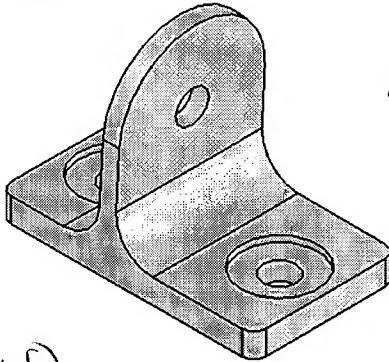
NOTE: Date & initial all entries

**PRELIMINARY ISSUE**

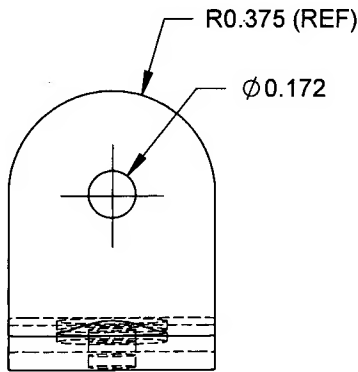
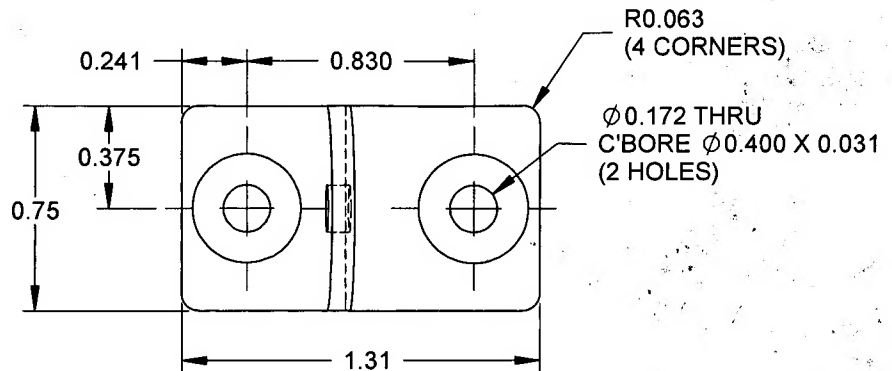
**UNDER REVIEW**

06.07.18 LE

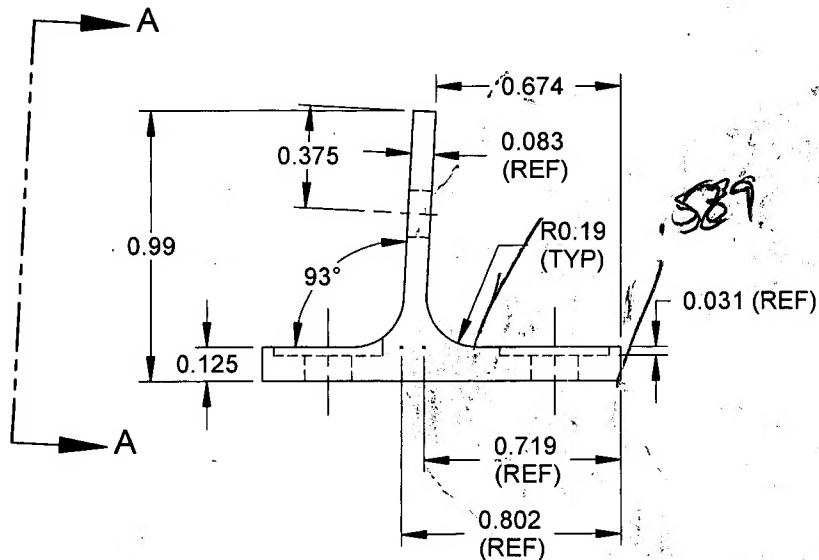
DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED	DRAWING NO. <b>D3538</b>	REV. A SHEET 1 OF 1
DATE <b>06.09.05</b>	TITLE <b>HINGE BRACKET</b>		SCALE 1:1
REV A	DATE 06.09.05	DESCRIPTION NEW ISSUE	



MISOSI  
6061 T6 1.50 X .75



**AUXILIARY VIEW A**



**D3538-1 HINGE BRACKET**

**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX

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0.260  
+ .135

11.01  
26.46  
16.32  
29.00

5.85  
6.

10.50  
25.71  
10.83  
25.10



WATER BIRD

DART AEROSPACE LTD		Work Order:
Description:		Part Number: D3538-1
Inspection Dwg:	Rev:	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

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First Article

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Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.830	$\pm 0.005$	0.832	✓			
R.063	$\pm 0.01$	R.063	✓			
$\phi$ .172	$\pm 0.005$ $\pm 0.001$	$\phi$ .172	—			
1.31	$\pm 0.03$	1.312	—			
0.750	"	0.751	✓			
0.375	$\pm 0.005$	0.374	✓			
0.241	"	0.244	✓			
0.083	$\pm 0.01$	0.090	✓			
R.19	"	R.187	✓			
0.031	"	0.032	✓			
0.125	"	0.126	✓			
0.99	$\pm 0.03$	0.993	✓			
<del>0.375</del>	<del><math>\pm 0.005</math></del>					
93°	$\pm 0.5^\circ$	93°	✓			
0.375	$\pm 0.005$	0.374	✓			
0.674	$\pm 0.01$	0.668	✓			

Measured by: <i>RE</i>	Audited by: <i>SD</i>	Prototype Approval:
Date: 06.10.03	Date: 06.10.04	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	